

20

DART AEROSPACE LTD	Work Order:	20773
Description: Chafing Shield	Part Number:	D3190-1
Dwg: D3190 Rev. A	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>[Signature]</i>	04.04.20	4
2	GA	Cut blank: 9.25" x 3.13" Material: AISI 304/316 SS 0.020" thick sheet (M304S25GA) Batch: <u>M2070</u>	<i>ml</i>	04-05-05	4
3	GA	Grind corner as per Dwg D3190	<i>ml</i>	04-05-05	4
4a	GA	Deburr	<i>ml</i>	04-05-05	4
4b	QC5	Inspect	<i>ml</i>	04-05-05	4
5	GA	Roll as per Dwg D3190	<i>2</i>	05-01-04	4
6	QC5	Inspect work to Step 5	<i>B</i>	05-01-05	4
7	LG	Identify and Stock	<i>jl</i>	05-01-06	4
8	AC	Cost / part <u>13.37</u>	<i>SAC</i>	05-01-07	4
9	DC	Close W/O <u>13.37</u> Inspect Level 21	<i>[Signature]</i>	05.01.14	4

Rev	Date	Change	Revised By	Approved
A	03.05.26	New issue	KJ/RF <i>RF</i>	<i>[Signature]</i>

RELEASED
03.05.27 *[Signature]*

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 20773		WORK ORDER NON-CONFORMANCE D3190-1					
DATE	STEP	Description of NC section A	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Intial				
04-05-05	2	Scrap 4 pieces 9.25 x 3.130 Because the blade of Broke is not sharp. Try to fix the pieces with grind	Scrap 4 pieces destroy made 4 new one with Hand made	ml 04-05-05	[Signature] 05-01-12	[Signature] 05-01-12	[Signature] 05-01-12

PAR#: N/P

Fault Category: Manuf/Misc

DQA: [Signature]

Date: 05/01/13

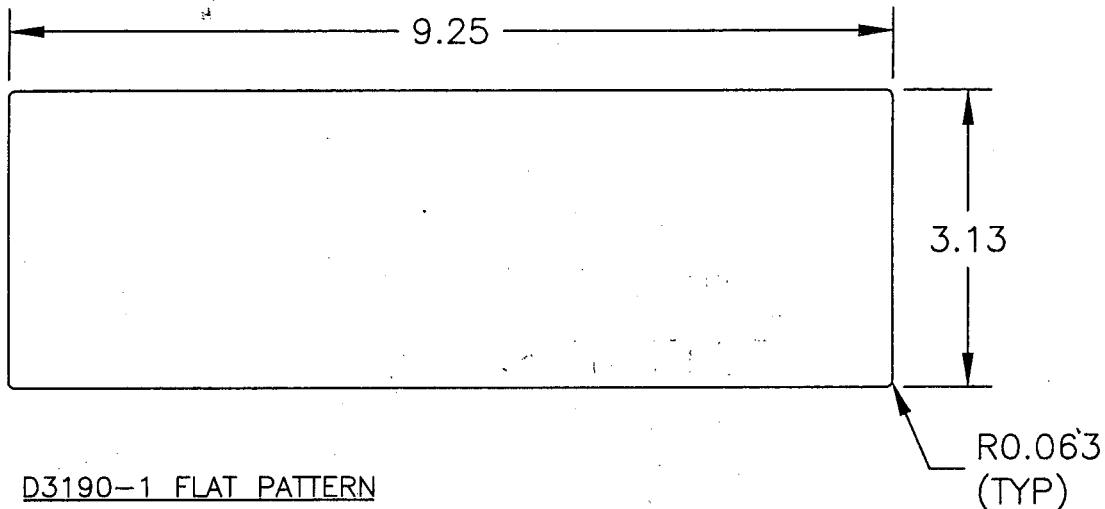
QA: N/C Closed: [Signature]

Date: 05.01.13

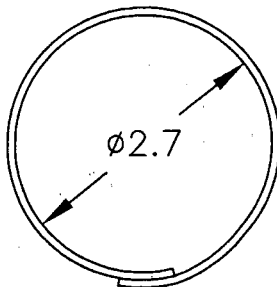


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

RELEASED
03.05.22 #



D3190-1 FLAT PATTERN



D3190-1 ROLLING DETAIL
NOT TO SCALE

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 20773

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 27, 2004
03:08 pm

Work Order No : 0020773
Project Name : D3190-1
Project For : WK420
Work Order Type : Main
Main WO Number :
House Part Number : D3190-1
Description : Chafing Shield
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 04-27-04
Est Finish Date : 05-19-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00